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Information for Applicants for POULTRY INSPECTION

AMS-219

UNITED STATES DEPARTMENT OF AGRICULTURE
Agricultural Marketing Service
Washington, D. C.

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Revised July 1964

I N F O R M A T I O N F O R A P P L I C A N T S
F O R P O U L T R Y I N S P E C T I O N

SECTION I. OUTLINE OF PRELIMINARY STEPS FOR APPLICANTS

A. Poultry Products Inspection Act.

The Poultry Products Inspection Act (P.L. 85-172) became law on August 28, 1957. Its purpose as stated in the Act is " . . . to prevent the movement in interstate or foreign commerce or in a designated major consuming area of poultry products which are unwholesome, adulterated, or otherwise unfit for human food."

B. Plants Required to Receive Inspection.

Any establishment (except producers who qualify for exemption under the Act) slaughtering poultry for transportation or sale in interstate commerce is required under the law to receive inspection. Also required to have inspection is any establishment slaughtering poultry for transportation to an official establishment even though both plants are in the same State; for example: When New York dressed poultry is slaughtered in one plant and moves to an official eviscerating plant - both plants would be required to have inspection service.

C. Where Application Forms can be Obtained.

Application forms may be obtained at any one of the following Inspection Branch, Poultry Division, Agricultural Marketing Service, U. S. Department of Agriculture offices:

1. Facilities Section, Washington, D.C. 20250 Telephone: DUDley 8-4855
2. NORTHEASTERN AREA, 1007 U. S. Customs House, Second & Chestnut Streets, Philadelphia, Pennsylvania 19106. Telephone: 597-4552

States Supervised:

Connecticut, Delaware, District of Columbia, Maine, Maryland, Massachusetts, New Hampshire, New Jersey, New York, Pennsylvania, Rhode Island, Vermont, Virginia, West Virginia.

3. SOUTHEASTERN AREA, Room 321, 900 Peachtree Building, 900 Peachtree Street, N.E., Atlanta, Georgia 30309. Telephone: TRinity 6-3311 Ext. 5015

States Supervised:

Alabama, Florida, Georgia, Puerto Rico, North Carolina, South Carolina, Tennessee, Mississippi - All counties except Washington

4. MIDWESTERN AREA, 504 Iowa Building, Des Moines, Iowa 50309
Telephone: 284-4530

States Supervised:

Colorado, Indiana, Iowa, Kentucky, Michigan, Minnesota, Nebraska,
North Dakota, Ohio, South Dakota, Wisconsin.

Illinois - All counties except Alexander.

Kansas - All counties except Allen, Bourbon, Cherokee, Crawford,
Labette, and Neosha.

Missouri - All counties except Barry, Barton, Butler, Carter, Cedar,
Christian, Dade, Dallas, Douglas, Dunklin, Greene, Howell,
Jasper, Iacleda, Lawrence, McDonald, Mississippi, New
Madrid, Newton, Oregon, Ozark, Pemiscot, Polk, Ripley,
Scott, Shannon, Stoddard, Stone, Taney, Texas, Vernon,
Webster, and Wright.

5. SOUTHWESTERN AREA, Room 3-109, 500 S. Ervay Street, Dallas, Texas 75201
Telephone: RIverside 9 - 2691

States Supervised:

Arkansas, Louisiana, New Mexico, Oklahoma, Texas

Illinois - Alexander County.

Kansas - Counties of Allen, Bourbon, Cherokee, Crawford, Labette,
and Neosha.

Missouri - Counties of Barry, Barton, Butler, Carter, Cedar,
Christian, Dade, Dallas, Douglas, Dunklin, Greene,
Howell, Jasper, Iacleda, Lawrence, McDonald, Miss-
issippi, New Madrid, Newton, Oregon, Ozark, Pemiscot,
Polk, Ripley, Scott, Shannon, Stoddard, Stone, Taney,
Texas, Vernon, Webster, and Wright.

6. WESTERN AREA, Room 808, U. S. Appraisers Building, 630 Sansome
Street, San Francisco, California 94111 Telephone: 556-3763

States Supervised:

Alaska, Arizona, California, Hawaii, Idaho, Montana, Wyoming,
Nevada, Oregon, Utah, Washington.

D. How to Make Application.

Make application for inspection by completing the form, "Application for Inspection," in three copies, and mailing all three to: The address of the local Area Inspection Office, Inspection Branch, Poultry Division, AMS, USDA. (See example Exhibit 1.)

E. Qualifying a Plant to Receive Inspection.

1. To qualify a plant to receive inspection, prepare four sets of prints of plant drawings in accordance with the requirements established by Section 81.14 of the "Regulations Governing the Inspection of Poultry and Poultry Products," and forward them to: Facilities Section, Inspection Branch, Poultry Division, AMS, USDA, Washington 25, D. C.
 - a. See attached copy of regulations and section II herein. Prints shall consist of floor plans, building elevations, and a plot plan.
 - b. Prints will be either approved or returned for changes and amendment. If approved, one approved copy will be returned to the applicant, and three copies will be retained by the Government. (The regulations state that technical assistance may be provided in bringing plants into compliance, where requested.)
2. See that the plant conforms to the approved prints.
3. Notify the Area Inspection Office when plant is in compliance with prints.
4. The Area Inspection Office will arrange for a final survey. If at the time of final survey, it is determined that the plant is in compliance, the plant is eligible to receive inspection. Subsequently, a letter of plant approval will be forwarded to the establishment. Before service is installed, an official plant number will be assigned to the establishment.

F. Labels.

The labels used on poultry must be approved by the Poultry Products Section, Inspection Branch, Poultry Division, AMS, USDA, Washington 25, D. C. in advance of the time service is to be inaugurated in an establishment. It is recommended that applicants become thoroughly familiar with the requirements of Sections 81.125 through 81.148 of the regulations before definite plans for labels are completed. Application forms for label approval should be requested from the local Area Inspection Office.

SECTION II. BUILDING CONSTRUCTION AND FACILITIES.

When planning a new poultry processing plant or remodeling a plant to meet the minimum standards as set forth in the regulations, you should become fully familiar with Sections 81.31 through 81.43 of the regulations. The following information is presented in order to clarify items which have given some applicants difficulty in interpretation:

A. Plant Building.

The outside construction of the building has no particular bearing on the eligibility of an applicant to receive inspection, except that the building shall be of sound construction and in good repair.

B. Live Poultry, Inedible Areas, and Trucking Areas.

The truck areas where live poultry is received, refuse removed and processed poultry is shipped from the plant, should be constructed of concrete properly sloped to drains connected with the plant's waste water disposal system.

C. Inedible Room.

The inedible room should be equipped with power exhaust fans to be properly ventilated. The room should be large enough to store all empty refuse containers as well as the full containers. The walls, floors, and ceilings shall be of hard, smooth material impervious to moisture. Hot and cold water outlets and hose should be provided in this room. It should be in a location convenient to the processing room but should be entirely separate and have tight fitting doors. Adequate floor drainage shall be provided.

D. Poultry Dressing Room:

The poultry dressing room shall be separated from the eviscerating room by a wall which extends to the ceiling. Only minimum openings are permitted in the separating wall for conveyors. Doors between the rooms shall be equipped with self-closing devices. Floors should be properly drained by either trench or deep sealed trapped drains. Keep in mind the formula of one drain for every twenty foot bay which gives ten feet from the high point to the drain. The floor drains should be located so that the flow of all waste water is direct to drains. The walls should be smooth-finished cement plaster or other impervious material, such as tile, from floor to ceiling. Some types of plastic and other paints which are impervious to moisture when properly applied to walls are satisfactory. Sufficient hot and cold water clean-up outlets, with racks for hose, shall be supplied. For proper equipment arrangement, the boiler room should be located near the scald tank. Mechanical ventilation (exhaust fan) should be provided in the scald tank area.

E. Bleeding Area.

The bleeding area shall be completely separated from the scalding and dressing areas except for minimum openings for conveyors. It is recommended that a water flushed bleeding area be used to provide an acceptable sanitary operation. It should be constructed of tile or trowel-finished Portland cement. The bleeding area should have the floors sloped to a drain. Trench drains are dangerous in this floor if the arch is not water-flushed, due to the slippery coagulated blood. If necessary, blood may accumulate in this area. The width and length of the area will depend on the size of birds to be processed and rate of production. The poultry should be completely bled before it reaches the scald tank.

F. Poultry Eviscerating Room.

The floors should be of concrete, float-finished, properly pitched to drains, and placed so that the waste water will not drain over the floor area. If closed drains are used they shall be vented to the outside. (Again keep in mind the formula of one drain in the center of each twenty foot bay.) The side walls shall be smooth-finished and impervious to moisture to a height of at least six feet above the floor. We recommend cement plastered or tiled walls. The remainder of the walls to the ceiling shall be smooth and resistant to moisture.

G. Length of Eviscerating Line.

In calculating the length of eviscerating line required, keep in mind the Graphic Standards recommended under Dimensions of Human Figure - that 36 inches of linear line space are needed for an employee at work with elbows out sideward. The work space an employee needs when standing and working on a job before him is 2 feet 10 inches (from back to tip of fingers). When sitting 2 feet 2 inches are required (back to tip of fingers). Keep in mind that for efficient operation, the product should move in an even flow toward the packing and shipping area.

H. Cooling and Packing Area.

The floors in the cooling area where tanks are drained shall have ample drainage. The side walls should be cement plastered or tiled for a minimum of six feet. Plastic coated walls are also satisfactory. The remainder of wall to the ceiling shall be smooth and resistant to moisture.

I. Floors, Walls and Ceilings.

To promote good sanitation, the floors, walls, and ceilings in the various workrooms should be constructed of material that can be readily kept clean. Wood structures and equipment are absorbent

and difficult to keep clean. Therefore the use of wood is limited to high ceilings and in areas where moisture is at a minimum. Properly applied plastic covering of wooden surfaces is satisfactory. The use of marine plywood is preferable to dressed and matched lumber, as there are fewer joints that offer a harbor for roaches or other vermin.

Floors requiring drainage shall be constructed of impervious material, such as dense concrete or vitrified floor brick of good quality laid on a concrete base.

The accident rate is high in poultry plants. This is why we caution you that on all equipment, waste water should flow direct to drain, not over large areas of the floor. Drainage pipes or loose equipment should not extend over the floor. Safety guards should be installed on all mechanical equipment.

Interior walls should be smooth and flat so far as structural considerations permit, and ceiling surfaces should be smooth and flat. Wall surfaces in workrooms should be constructed of glazed brick, glazed tile, smooth Portland cement plaster, acceptable plastics, or other nonabsorbent material.

Ceilings should be of a height of at least 10 feet.

To avoid damage to window glass from impact or hand trucks, the window sills should be 3 feet or more above the floor. Window sills should be sloped about 45 degrees to promote sanitation.

J. Floor Drainage.

All floors where wet operations are conducted should be well drained. A slope of $1/8$ inch to $1/4$ inch per foot to drainage inlets is desirable for usual conditions. Floor drains should be so located that high points of the floor are not over 10 feet from a drain. In packaging areas high points of the floor should not be over 15 feet from a drain. To avoid accidents, excessively smooth floors should be avoided. Good results have been obtained by laying concrete floors with a topping containing hard particles, such as carborundum, so as to afford a good foothold, or by giving them a wood float finish.

Each floor drain, including blood drains, should be equipped with a deep-seal trap (P-U or S-shaped are acceptable; Bell type traps are not acceptable). The drainage lines should be at least 4 inches in diameter and properly vented to the outside air. Drainage lines from toilet bowls and urinals shall not be connected with other drainage lines within the building unless equipped with backwater check valves to prevent backing up and shall not discharge into a grease catch basin located inside the building. Where there is likelihood that the water seals in traps will evaporate without

replenishment from floor drainage, as in the case of dry-storage rooms, the floor drains should be provided with suitable removable plugs or be installed in such a manner that will accomplish the objectives of these requirements. (See §81.35 (b) (3).)

K. Sewage Disposal.

Sewage may be discharged into a municipal sewer system and if this is permitted by local ordinance it is most desirable. If the discharge is into a stream, the flow of water in the stream should be sufficient at all seasons of the year to carry the sewage well away from the plant. It is recommended that the system be checked by local health authorities having jurisdiction over such matters to determine if it is acceptable. A letter from the proper health authority (state, county, city) indicating that the proposed sewage system is acceptable should be submitted to the Area Inspection Office before requesting a final survey of the plant prior to inauguration of inspection.

L. Water Supply.

The water supply must be ample, potable (safe for drinking) suitable for food processing, and distributed throughout the plant under adequate pressure and in quantities sufficient for all operating needs.

Based on experience of the Inspection Service and on estimates furnished by processing plants about 25 gallons of water are needed to process a turkey, 5 gallons for a fryer, and 10 gallons for fowl. Sufficient hot and cold water connections with hose (maximum length 100 feet) and racks for clean up purposes shall be provided.

Nonpotable water is permitted for limited purposes only in an official plant such as in the feather flow-away (not on picking aprons or in picking machines) on condensers and in sewer lines for moving heavy solids. NO CROSS CONNECTIONS BETWEEN POTABLE AND NONPOTABLE WATER LINES WILL BE PERMITTED.

It is necessary that a satisfactory water report be submitted before inspection may be inaugurated. This may be obtained from the State Department of Health or some other agency authorized by the State Department of Health to issue the report. Forms to be used in supplying the Inspection Branch with this report are provided to all firms requesting inspection service. (See Exhibit No. 2)

M. Ventilation.

Ample ventilation shall be provided. It may be furnished by means of intake fans, exhaust fans, forced air duct systems, or a combination of the above methods. The fresh air intakes should be so located that the air is not contaminated with dust, smoke, etc. If this is not possible, filtered air should be provided. Ventilation

should prevent the condensation of moisture and its dripping into the edible products. The movement of air should be from the edible products rooms toward the poultry dressing and live poultry area.

N. Doors.

Doors to food processing rooms and refuse rooms shall be equipped with self-closing devices. Doors to restrooms shall be self-closing.

O. Poultry Conveyors.

Overhead conveyor lines shall be raised in areas where traffic moves in and out to a height sufficient to prevent pushing of the raw product to one side. For an efficient operation the overhead lines should have as few turns as possible. Product should move from the poultry dressing room, through eviscerating room, chilling room, packing room to the refrigerated holding room.

P. Restroom Facilities.

The toilet facilities should be separate from the cloak room. Ample space should be provided. We do not specify lockers, but shelves and clothes racks are to be provided. Partitions and doors should be furnished for each toilet. Toilet facilities should be arranged so that they will be conveniently located to the processing rooms. The toilet rooms should be ventilated to the outside of the building with the aid of an exhaust fan.

Q. Lunch or Breakroom.

A room should be provided to be used for eating, smoking, and housing vending machines.

R. Inspector's Office.

The inspector's facilities are explained in the regulations but we recommend that they be located near the eviscerating operation, in order that he may be close to the operation for observation. Private toilet and lavatory facilities are recommended but not required. For two USDA employees, the room should be at least 7 feet by 10 feet. Ten square feet of additional space should be added for each employee beyond two in number.

S. Ice Machines or Crushers.

Ice machines or crushers should be so located that the ice can be handled in a sanitary manner. To save time and labor, the ice should drop directly into a wheeled tank which can be easily moved. Block ice shall be washed before it is crushed. Ice storage facilities should be constructed so as to prevent employees from walking on the ice.

T. Lavatories.

Lavatories should be conveniently located in processing rooms for the use of employees and inspectors. Each lavatory shall be supplied with hot and cold running water, liquid soap in a suitable dispenser, an ample supply of sanitary towels, and a suitable receptacle for used towels. Lavatories serving processing areas shall be other than hand operated. Ordinarily, one to three lavatories should be sufficient in each food processing room.

U. Equipment and Utensils.

Equipment shall be so constructed that it can be readily cleaned. Rust-resisting metal, such as stainless steel, should be used for equipment and utensils. Other metals, such as galvanized metal and aluminum are acceptable but they are difficult to clean and not too practical to use over a long period of time. Cutting boards should be constructed of hard maple or other suitable material such as plastic.

Water-wasting equipment, such as washers, cooling tanks and cooking vats, should be installed so that waste water is delivered into the drainage system without flowing over the floor. Chilling and cooking vats should be provided with overflow pipes at least two inches in diameter. Each overflow pipe shall be equipped with a sanitary type connection to facilitate cleaning. Stationary equipment and equipment not readily movable should be placed at least 30 inches from walls, posts, and other fixed parts of the building and from other equipment to facilitate ready cleaning of outer surfaces. Vent stacks from covered cooking vats and open vats shall be so arranged as will preclude drainage of condensate back into the vats.

A separate washroom or area should be provided for cleaning hand trucks, utensils, and containers such as pans and trays. The room or area shall have adequate light and ventilation and an impervious, well-drained floor, and impervious walls and ceiling.

V. Drawings.

Drawings and specifications submitted shall comply with Section 81.14 (a) through (d) of the regulations.

We recommend the following method for showing information and specifications on prints.

Prints are to be direct contact prints of any color. Photostats are not in this category and are not acceptable.

All information (Section 81.14 (b) 1 through 11) to be shown on the floor plan, such as equipment, ventilation, floor drains, self-closing doors, hot and cold water outlets, etc., should be drawn or printed in its proper location on the print.

Please show specifications (Section 81.14 (c) 1 through 13) on the print as indicated in the Example of Specifications.

EXAMPLE OF SPECIFICATIONS

ROOM	WALLS	FLOOR	TYPE CEILING	FINISH OF CEILING	HEIGHT OF CEILING
					VARIES
Dressing Room	Cement Plaster	Concrete	Open to Roof	Galvanized Metal	10-18 ft.
Eviscerating Room	Glazed Tile	"	Closed	Cement Plaster	11 ft.
Packing Room	"	"	"	"	"
Refuse Room	Cement Plaster	"	"	"	"
Cooler	"	"	"	"	9 ft.
Freezer	"	"	"	"	"
Men's Restroom	Painted Marine Plywood	"	"	Painted Marine Plywood	"
Women's Restroom	"	Tile	"	"	"
Etc.					
Etc.					

Screens.

All windows opened for ventilation are screened.

Drainage.

Minimum 1/4" per foot to drain. All drains deep seal trapped and vented to conform to USDA, city and state regulations. Floor drain openings 4" in diameter. Main drainage line 8" in diameter, laterals 4" in diameter. House drainage lines and toilet soil lines separate to a point outside the building. (If not separate, they must be installed with backwater check valves to positively prevent backing up, and so indicated on print.)

Heating.

Steam, hot air, etc.

Water Supply.

Public water supply. Gallons available per minute 250. No nonpotable water in plant.

Hot Water Facilities.

Boiler, mixing valves. Fifteen H.P. boiler.

Number of Men and Women Employees to Use Each Toilet Room.

14 women and 12 men.

Sewage Disposal. City Sewer system, etc.

Approximate Hourly Rate of Production. Fowl 900, fryers 1200, hen turkeys 900, tom turkeys 660, 1,000 lbs. raw boned turkey meat (rolls or roasts), 5,000 lbs. ready-to-cook fowl (canned product), etc.

The sheets of paper on which prints are made shall not exceed a size of 34" x 44". The drawings other than of the plot plan shall be made to a scale of 1/8" per foot. The plot plan may be drawn to a scale of not less than 1/32" per foot. The drawings shall indicate the scale used and shall also indicate the floor shown (i. e., basement, first, or second).

Space for Approval Stamp.

A contrasting space (white) of at least 2-1/2" x 4" is necessary on each sheet of print for the placement of the formal mark of approval.

For further information, please direct your questions to:
"Facilities Section, Inspection Branch, Poultry Division,
Agricultural Marketing Service, United States Department of
Agriculture, Washington, D. C. 20250"

SECTION III. SAMPLE FORMS AND EXHIBITS.

Exhibit No. 1

UNITED STATES DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
POULTRY DIVISIONAPPLICATION FOR INSPECTION
UNDER POULTRY PRODUCTS INSPECTION ACT

Application is hereby made for poultry inspection, in accordance with the applicable provisions of the Regulations Governing the Inspection of Poultry and Poultry Products (7 CFR Part 81), at the following - designated plant:

NAME OF PLANT	MONTH AND YEAR WHEN PLANT WILL BE READY TO OPERATE UNDER INSPECTION PROGRAM
Colorado Poultry Company	July 1962

STREET ADDRESS	CITY AND STATE
1100 - 4th Street	Smith Center, Colorado

TYPE OF POULTRY PROCESSING OPERATIONS:

☒ DRESSING (Includes slaughtering and picking)☒ Eviscerating☐ CANNING (Includes cooking, smoking, raw boning, preparation of pies, dinners and turkey rolls)

CHECK BELOW ONLY IF NOT A PART OF THE
Eviscerating OPERATION:

☐ PACKAGING, REPACKAGING, OR CUTTING UP
POULTRY NOT Eviscerated at Applicant's
PLANT☐ OTHER (Explain) _____

Will the poultry or poultry products processed as indicated above be shipped
by applicant, or with his knowledge by other persons, in interstate or foreign commerce?

YES NO

☒ ☐

In making this application the applicant agrees to comply with the terms and conditions of the aforesaid regulations (including but not being limited to such instructions governing inspection of products as may be issued, from time to time, by the Administrator).

NAME OF APPLICANT (Owner)	OFFICE ADDRESS (Street, city and state)
John Doe	1100 - 4th Street Smith Center, Colorado

DATE	TITLE	BY (Signature)
April 1, 1962	President	

APPLICATION GRANTED (For use by USDA)

AGRICULTURAL MARKETING SERVICE

DATE	TITLE	BY (Signature)

WATER POTABILITY CERTIFICATE

INSTRUCTIONS FOR USE OF FORM: *Send three completed and signed copies of this form to the Area Poultry Inspection office.*

Date April 1, 1962

Poultry Division
Agricultural Marketing Service
U. S. Department of Agriculture

In accordance with the authority vested in me by the health agency of this State, I certify that the water supply of the following poultry processing plant has passed the tests prescribed by the State for drinking water and water suitable for food processing:

Name of Poultry Processing Plant John Doe Poultry Company
Street and No. 1260 - 15 Avenue
City and State Oakdale, Texas

1. Water for the above plant is supplied from a: *(Check as applicable)*

☐ Private Well ☒ Municipal Plant

2. If private well water is used, it is: *(Check one)*

☐ necessary, ☐ not necessary, to chlorinate the water to make it potable.

3. If private well water is to be chlorinated,
the parts per million (p.p.m.) of available chlorine to be used are: _____

Certifying Officer (Only the signature, title, and
(SIGNATURE)

Title address of the person specifically

Street and No. authorized by the State Health

City and State Department will be accepted.)

IMPORTANT - PLEASE COMPLETE

Name of State Approved
Certifying Agency Texas State Department of Health
Street and No. 1100 West 49th Street
City and State Austin 5, Texas

U. S. DEPARTMENT OF AGRICULTURE
Agricultural Marketing Service
Washington, D. C. 20250

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